

GREEN

Dart Aerospace Ltd.

Date: Wednesday, 9/6/2006 3:46:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 28447	
Estimate Number : 10534	
P.O. Number : N/A	Part Number : D2574
This Issue : 9/6/2006 S.O. No. : N/A	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 27995	Material : N/A
Written By : <u> </u>	Due Date : 9/13/2006 Qty: 6 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev: I As Rev: RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101005

7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: 305350

Er 06/09/13 x6

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 328477 Double check by: J.L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

mL/Er 06/09/12 6

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

mL 06/09/12 6

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mL 06/09/12 6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/6/2006 3:46:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 28447

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/09/22 6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Qm 06-09-27

(E)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN (Ref: 4.3.5.1) as per QSI 005 4.3

gl 06/09/28 x 6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 9/10/05 6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 111003

PC 9/10/05

(6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/06 (6)

Job Completion



U 06-10-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28447
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.506	3.506	3.498	3.506		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.006		
F	0.490	0.510		0.501	0.501	0.500	0.501		
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684						
I	0.490	0.510		0.501	0.499	0.500	0.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.506	2.499	2.500		
O	4.119	4.129		4.122	4.122	4.124	4.122		
P	0.115	0.135		0.121	0.122	0.122	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.253	0.253	0.252		
S	0.115	0.135		0.119	0.120	0.117	0.118		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.239	0.241	0.239		
W	0.115	0.135		0.126	0.126	0.124	0.123		
X	0.307	0.312		0.309	0.309	0.308	0.309		
Y	0.760	0.765		0.760	0.760	0.762	0.760		
Z	0.352	0.372		0.369	0.369	0.369	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.626	0.629	0.629	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.246	0.246		
AE	1.500	1.520		1.502	1.509	1.509	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.249	0.251	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.035	0.035	0.035		
Accept/Reject									

Measured by:	One
Date:	06/09/18

Audited by:	MS
Date:	06/09/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	28447
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

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D	1.745	1.755		1.749	1.750				
E	7.990	8.010		8.006	8.006				
F	0.490	0.510		0.501	0.499				
G	0.257	0.262	DT8683	—	—				
H	0.375	0.380	DT8684	—	—				
I	0.490	0.510		0.506	0.498				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.568	0.566				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.122	4.122				
P	0.115	0.135		0.123	0.122				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.119	0.120				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.230	3.236				
V	0.230	0.250		0.240	0.239				
W	0.115	0.135		0.122	0.125				
X	0.307	0.312		0.308	0.309				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.369	0.370				
AA	0.470	0.530		0.500	0.506				
AB	0.615	0.635		0.627	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.247	0.247				
AE	1.500	1.520		1.510	1.513				
AF	0.115	0.135		0.125	0.135				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.249	0.249				
AI	2.000	2.020		2.006	2.000				
AJ	0.023	0.043		0.025	0.035				
Accept/Reject									

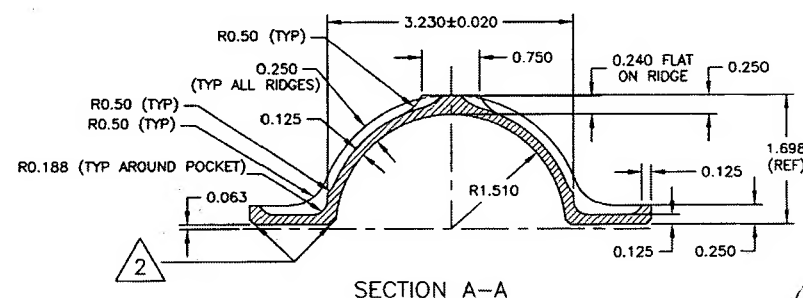
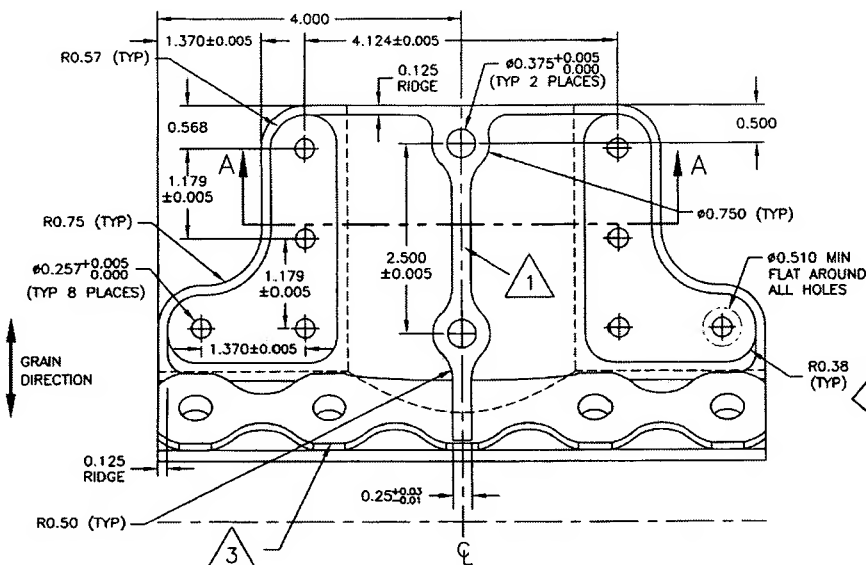
Measured by:	<i>ml</i>
Date:	06/09/18

Audited by:	MS
Date:	06/09/22

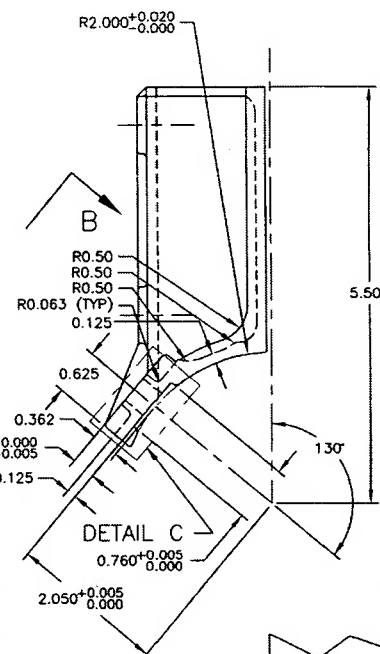
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

RELEASED

05.12.06



SECTION A-A

DETAIL C
SCALE 2:1

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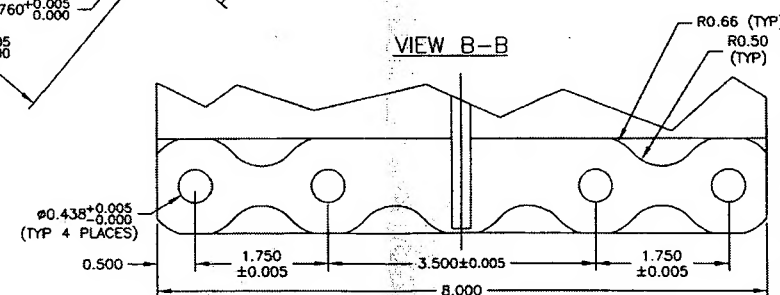
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NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE
		SCALE
		2:3

DARTDART AEROSPACE LTD.
WILMINGTON, ONTARIO, CANADA

REV. E

SHEET 1 OF 1

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